

SPLIT-1

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:36:33 AM
 ser: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32643 -1
 Estimate Number : 12578
 P.O. Number : N/A
 This Issue : 5/25/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 31443

Drawing Name : ARM
 Part Number : D3560041
 Drawing Number : D3560 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 6/5/2007

EFFECTIVE 07.06.05 AUTH SP
 RELEASED 07.06.06 DATE SP

Written By : 07.05.25
 Checked & Approved By : 07.05.25
 Comment : Est Rev:A New Issue 07.05.24 EC

Qty: 10 30 Unit: Each

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar 50" x 5.0"

Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: M17625

SA 07.05.30

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 16.750" long

SA 07.05.32 (30)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: B
- 2-C'sink 0.196" hole on manual mill as per dwg D3560
- 3-Deburr per dwg D3560

SL 07.06.01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JH 07.06.01

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 07.06.06

B28600

WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	DO NOT POWDER COAT PART. CHEM CONVERSION COAT ONLY. PART WILL BE FINISHED AFTER ASSEMBLY WITH STEP REF ATTACHED DS EMAIL.				UP 07.06.06 per QSI 042		
07.06.06	11	Press Pit Qty 1 D2808 Bushing B 32752 qty 2 + 4 FF 07/06/12 B 28600 qty 3						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	3	- 2 parts are scrapped hole $\phi .507^{+0.000}_{-0.001}$ are oversize by too much $\phi 0.510^{+0.000}_{-0.001}$ & $\phi 0.513^{+0.000}_{-0.001}$	QSI 042	- Destroy & Replace	JL 07/06/06	07/06/06	QSI 042	07/06/06

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

B32641

ff. 07.06.06 (5)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

ff. 07.06.07 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ff. 07.06.07

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ff. 07/06/07 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ff. 07.06.12
ff. 07.06.07 4-5

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

NO POWDER COAT
SEE W/D CHANGE



Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ff. 07/06/07 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2006/15
6070615

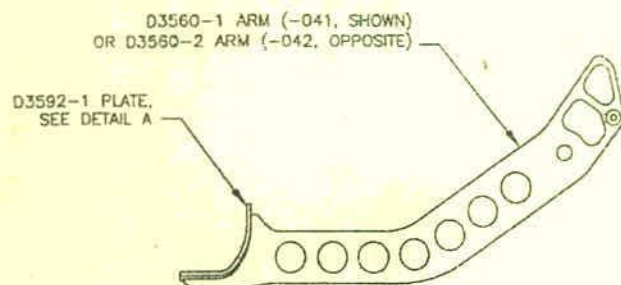
Job Completion



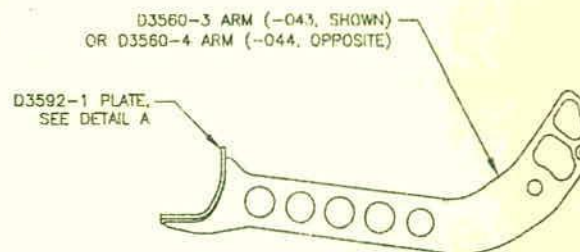
POSITIVE RECALL

EFFECTIVE _____ AUTH _____

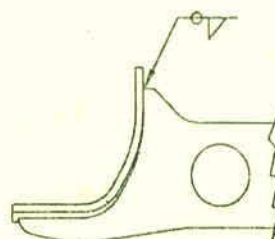
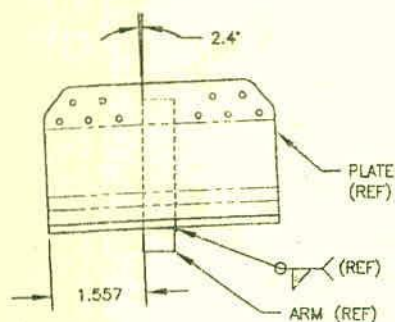
RELEASED u DATE 07/06/15



**D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)**



**D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)**



**DETAIL A
(SCALE 1:1)**

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07-05-07

B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q	DRAWN BY q
CHECKED	h	APPROVED h
DATE	07.01.15	TITLE
		ARM WELDMENT
DRAWING NO. D3560		REV. B
SHEET 1 OF 3		SCALE 1:1

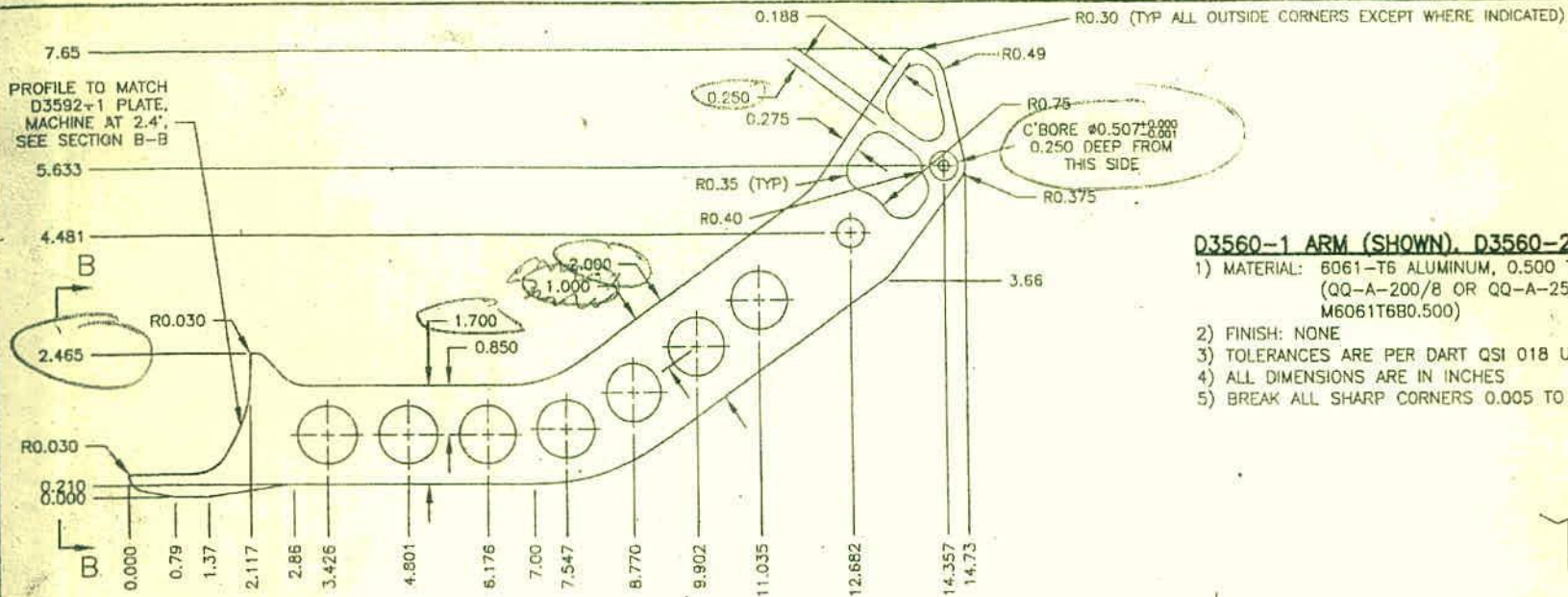
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DART

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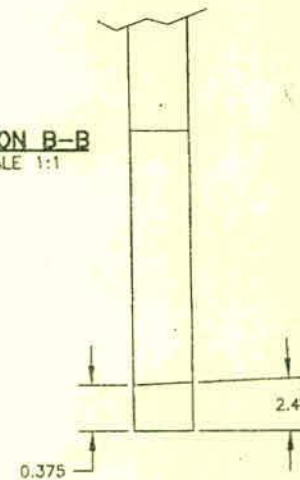
UNCONTROLLED
NO. 3264



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1



RELEASED

07.05.07

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DESIGN	90	DRAWN BY	90	DART	DART AEROSPACE LTD. HARRISBURG, OHIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D3560
DATE	07.01.15	TITLE	ARM WELDMENT	REV. B	SHEET 2 OF 3
				SCALE	1:2

DESIGN	DRAWN BY	 DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
49 	49 	
CHECKED	APPROVED	DRAWING NO. D3560
		REV. SHEET 3 OF
DATE	TITLE	
07.01.15	ARM WELDMENT	
		SCALE

DART AEROSPACE LTD		Work Order: 32648
Description: ARM		Part Number: 03560-1
Inspection Dwg: 03560 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.73	± .03	14.73	✓			
9.507	± .001	9.507	✓			
.250	± .010	.250	✓			
.188	"	.188	✓			
.250	"	.250	✓			
.275	"	.275	✓			
2.465	"	2.465	✓			
12.682	"	12.682	✓			
14.73	± .03	14.73	✓			
4.481	± .010	4.481	✓			
5.633	"	5.633	✓			
.188	"	.188	✓			
2.032	"	2.032	✓			
.500	"	.500	✓			
9.507	± .001	9.507	✓			
9.146	± .005	9.146	✓			
385 x .100"	± .010	385	✓			
1000	± .010	1000	✓			
2.000	"	2.000	✓			
1.000	"	1.000	✓			
.375	"	.375	✓			
2.13	± .03	2.13	✓			
.850	± .010	.850	✓			

Measured by: 36	Audited by: JL	Prototype Approval: [Signature]
Date: 07.06.01	Date: 07/06/01	Date: 07.06.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

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Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

